

SPKIT-2

Work Order ID 67619-2

Monday, March 28, 2011 3:06:11 PM



Page 1

Item ID: D2893-1

Accept



Setup Start



Revision ID:

Stop



Item Name: 2.75 Support

Start Date: 3/28/2011 Start Qty: 20.00

Required Date: 4/29/2011 Req'd Qty: 20.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date: 11/03/18

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2893

Rev B

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA081 Tumble & Deburr

11/04/18

①

110

QC2- Inspect parts off machine FAI/TAIB

0.00



QC

Memo

0.00

Quality Control

11/04/18

①

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

11/04/18

①

Work Order ID 67619

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Page 2

Item ID: D2893-1

Accept

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Start Date: 3/28/2011 Start Qty: 20.00

Required Date: 4/29/2011 Req'd Qty: 20.00

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QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref 4.3.5.1) per QSI005 4 3-Alum

0 00

Powdercoat

Memo

0 00

Powder Coating

Mask Inside Bore for Primming START TIME: 9:15 OVEN TEMPERATURE: 445 FINISH 400°
TIME: 11:04-16

140

QC3- Inspect Part Finish

0 00

QC

Memo

0.00

Quality Control

150

SprayPaint

0.00

SprayPaint

Memo

0 00

Spray Painting

Prime inside surface as per Dwg D2893 and QSI 005 4 3

Work Order ID 67619

Monday, March 28, 2011 3:06:11 PM



Page 3

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Cust Item ID:

Required Date: 4/29/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC14- Inspect Spray Paint

0 00



QC

Memo

0 00

Quality Control

11 04 17 (1)

170

Identify as per dwg & Stock Location

0 00



Packaging

Memo

0 00

Packaging

11 04-17

180

QC21- Final Inspection - Work Order Release

0 00



QC

Memo

0 00

Quality Control

11/4/18

11.04.18

Picklist Print

Monday, March 28, 2011 3:06:18 PM

Page 1

Work Order ID: 67619

Parent Item: D2893-1

Parent Item Name: 2.75 Support





Start Date: 3/28/2011

Required Date: 4/29/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C 02.11.26 Reformat; Added P/O KJ
 IPP D 06.04.19 removed alodine EC
 IPP Rev:E Added priming as per Rev B 07-04-30 JLM
 IPP F 08.03.19 Re-format EC verified by: DD
 IPP Rev:G 08-05-15 add QC14 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSK078  D2893-1 TURNING DETAIL		Manufactured	No			100	Each	10.0000	0.5 	10 <i>2</i>		<i>11/04/14</i>	

Location

Loc Qty

Loc Code

MAT060

10

64897

10

10

DART AEROSPACE LTD		Work Order:	17419
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.985	2.985	2.995	2.996	2.997
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.143	.140	.140	.140	.140
AD	0.040	0.060		.051	.050	.050	.050	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.151	.151	.151	.151	.148
AH	1.360	1.400		1.366	1.368	1.372	1.373	1.372
AI	0.040	0.060		.053	.053	.053	.054	.050
AJ	1.190	1.230		1.212	1.217	1.215	1.212	1.212
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.530	2.530	2.528	2.528	2.525
AO	84.39	90.39		84.39	84.39	84.39	84.39	84.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by: <i>SL</i>	Date: 11/11/19
Audited by: <i>[Signature]</i>	Date: 11/04/18
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART AEROSPACE LTD		Work Order:	67619
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	27	38	49	510
HAAS Section								
AA	2.985	3.005		2.997	2.995	2.995	2.994	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.049	.050	.051	.051	.051
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.148	.151	.151	.149	.149
AH	1.360	1.400		1.373	1.373	1.372	1.373	1.370
AI	0.040	0.060		.050	.055	.050	.056	.053
AJ	1.190	1.230		1.212	1.215	1.213	1.215	1.215
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.530	2.530	2.530	2.530
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	Date:
Audited by:	Date:
Prototype Approval:	Date:

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DART AEROSPACE LTD		Work Order:	67619
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	2.985	3.005		2.994	2.993	2.994	2.993	2.994
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.051	.050	.050
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.150	.151	.150	.150	.150
AH	1.360	1.400		1.373	1.370	1.372	1.373	1.367
AI	0.040	0.060		.054	.056	.053	.053	.053
AJ	1.190	1.230		1.212	1.216	1.216	1.217	1.214
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.525	2.525	2.526	2.528	2.526
AO	84.39	90.39		87.39	87.39	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:	SL	Date:	11/04/18
Audited by:	[Signature]	Date:	11.04.18
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	[Signature]

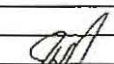
DART AEROSPACE LTD		Work Order:	17619
Description: Ø2.750 Support		Part Number:	D2893-1
Inspection Dwg: D2893	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

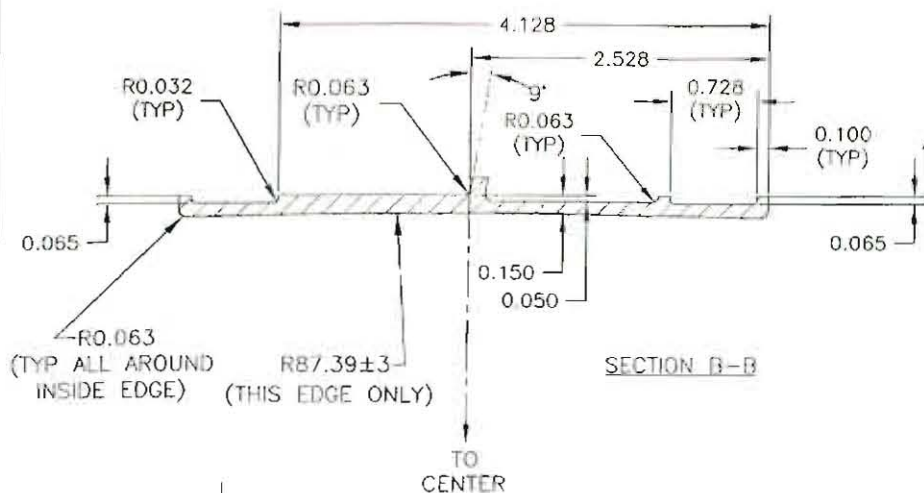
☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	16	217	318	419	520
HAAS Section								
AA	2.985	3.005		2.994	2.995	2.995		
AB	0.440	0.460		.440	.440	.440	.440	.440
AC	0.125	0.160		.140	.140	.140	.140	.140
AD	0.040	0.060		.050	.050	.050		
AE	0.188	0.193		.191	.191	.191	.191	.191
AF	0.125	0.160		.140	.140	.140	.140	.140
AG	0.140	0.160		.149	.146	.149		
AH	1.360	1.400		1.370	1.371	1.373		
AI	0.040	0.060		.053	.056	.053		
AJ	1.190	1.230		1.218	1.212	1.217		
AK	0.010	0.020		.015	.015	.015	.015	.015
AL	0.053	0.073		.063	.063	.063	.063	.063
AM	0.240	0.260		.250	.250	.250	.250	.250
AN	2.518	2.538		2.520	2.530	2.520		
AO	84.39	90.39		87.39	87.37	87.39	87.39	87.39
AP	0.261	0.266		.262	.262	.262	.262	.262
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR								
AS								
AT								
Accept/Reject								

Measured by:		Date:	11/04/14
Audited by:		Date:	11.04.18
Prototype Approval:		Date:	

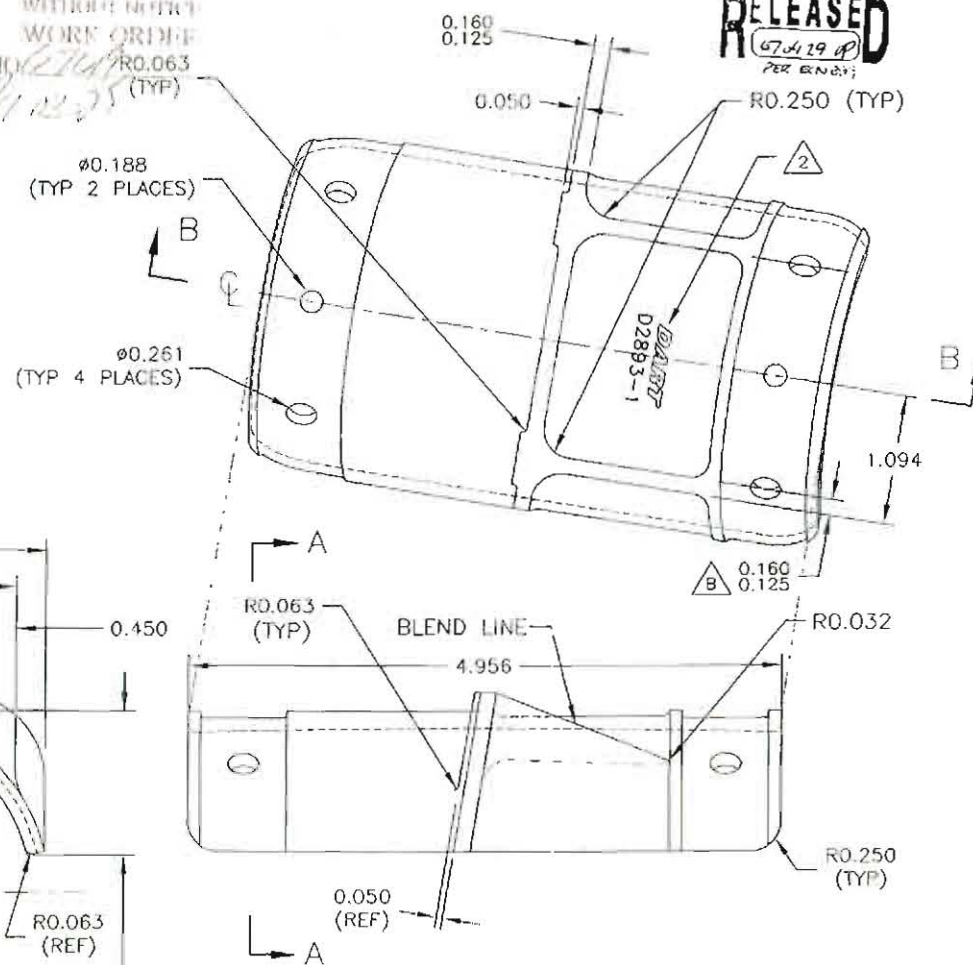
Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	
C	08.04.21	Reformat	KJ/JLM	

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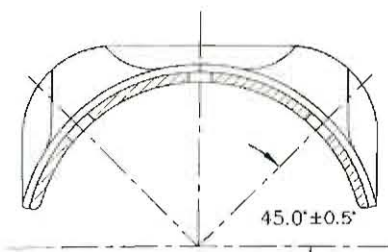


SECTION B-B

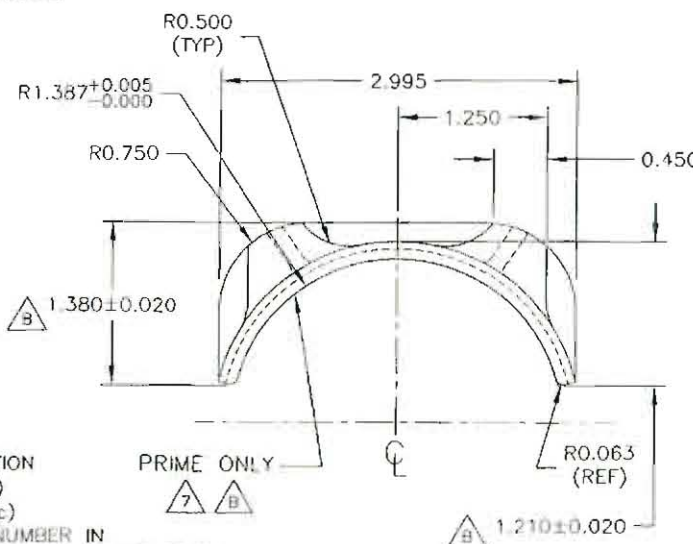
WITHOUT NOTICE
WORK ORDER
NO. 12747
DATE 12-25



RELEASED
67429 P
PER DART



SECTION A-A
TOOLING HOLE DETAIL



PRIME ONLY
7 B

- D2893-1
- 1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)
 - 2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP
 - 3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
 - 4) PART IS SYMMETRIC ABOUT CENTERLINE
 - 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 6) ALL DIMENSIONS ARE IN INCHES
 - 7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE
A	01.01.10	NEW ISSUE
DESIGN	90	DRAWN BY BAY
CHECKED	11	APPROVED 11
DATE	07.03.16	DRAWING NO. D2893
		TITLE Ø2.750 SUPPORT
		REV. B SHEET 1 OF 1 SCALE

DART DART AEROSPACE LTD.
HARROSBURY, ONTARIO, CANADA